

Work Order ID 133793

Wednesday, June 17, 2015 3:06:48 PM

133793

Page 1

Item ID: PB67-43001-03

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Aft Blade Fold Assembly

Stop ***NS2***

Start Date: 6/17/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/3/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: YMF.

Date: 15-6-17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-03	Rev C

JA

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001
page 2. 242 THREADLOCK batch: 132202

3 AUG 24 2015 DAS 24 9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

③ 1508-24 AD

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

W/O's 133654
133657
133658

683 AUG 25 2015 SEL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Page 2

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Revision ID:

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3

Cust Item ID:

Required Date: 7/3/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ AUG 25 2015

SV 120150825

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 133793

133793

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
C 10.09.24 as per Rev C dwg EC verified by:DD IPP Rev:D 10.10.21
added NAS1149F0532P DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 *240-107* SPRING SLOTTED PIN		Purchased	No			100	Each	176.0000	8				
			DAS 24 9-89						**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST568				176					
				m132006				176					
30345T21 *30345T21* LANYARD		Purchased	No			100	Each	19.0000	1				
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST570				19					
				M127979				19					
30345T24 *30345T24* LANYARDS		Purchased	No			100	Each	16.0000	3				
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST570				16					
				M127979				16					
3408A98 *3408A98* DETENT BALL SPRING PLUNG		Purchased	No			100	Each	42.0000	1				
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST570				42					
				123478				42					

JUL 21 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
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OTHER : _____																					

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Page 4

Work Order ID: 133793

133793

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

AN8-13A

Purchased

No

100

Each

7.0000

2 6

AN8-13A

Bolt

** JA

Location

Loc Qty

Loc Code

ST332

7

M127993

7

BSP43

Purchased

No

100

Each

43.0000

3

6

9

BSP43

RIVET

** JA

Location

Loc Qty

Loc Code

ST551

43

M128636

43

CR3213-4-05

Purchased

No

100

Each

211.0000

1

9

3

CR3213-4-05

RIVET

** JA

JUL 21 2015

Location

Loc Qty

Loc Code

CCK004

100

m131340

100

ST319

111

123301

107

m129764

4

D3440-1

Manufactured

No

100

Each

1.0000

1

3

***D3440-1* ***

Tube Guide (Supersedes B67-43001-25/-307)

** JA

Location

Loc Qty

Loc Code

Mezz2

1

111112

1

8134767

133698

1

2

Wednesday, June 17, 2015 3:06:46 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER :					

Picklist Print

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Page 5

Work Order ID: 133793

13379.3

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

D3440-3 Manufactured No

100 Each

1.0000

1 3

D3440-3 *

Clamp (Supersedes B67-43001-309)

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

41348

1

D3444-1 Manufactured No

100 Each

12.0000

1 2 1 3

D3444-1

Velcro Loop Belt

**

JA

JUL 21 2015

Location

Loc Qty

Loc Code

ST039

12

133002

12

D3447-9 Manufactured No

100 Each

1.0000

2 3 6

D3447-9 *

Swing Arm

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

114033

1

D3449-1 Manufactured No

100 Each

1.0000

1 6 3

D3449-1

Pad

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

111113

1

D3451-043 Manufactured No

100 Each

1.0000

1 2 3

D3451-043 *

Handle And Lock-Down Assembly

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

111743

1

2 x 133680

mt 15-8-17

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PB67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

D3451-045 Manufactured No

D3451-045

Handle And Lock-Down Assembly

100 Each 1.0000 1 3

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

111746

1

Each

84.0000

2 Y 1 3368 L CWK 15-8

1

3

**

JA

D3922-1 Manufactured No

D3922-1

Clip

Location

Loc Qty

Loc Code

ST064A

76

111733

76

ST066

8

111733

8

Each

15.0000

3

3

**

JA

MS17984-C408 Purchased No

MS17984-C408

PIN, QUICK RELEASE

← TO SHIRT

C410 ✓ AUG 24 2015
DAS
24
9-89
m 128056

Location

Loc Qty

Loc Code

ST315

15

m127376

2

m128051

13

100

Each

2.0000

3

9

**

JA

JUL 21 2015

MS17984-C418 Purchased No

MS17984-C418

QUICK RELEASE PIN

~~TO SHIRT~~

Location

Loc Qty

Loc Code

FG

1

123482

1

ST315

1

m132124

1

m132576

1

8

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Page 6

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Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PR67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

100

Each

4,770.000

9

27

MS21042L 4

Locknut

JA

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

160

m127813

160

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

522

m128300

8

m130388

7

m130922

97

m131618

24

m132123

386

27

MS21042L5

Purchased

No

100

Each

504.0000

1

3

MS21042L 5

Nut

JA

JUL 21 2015

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST260a

200

m132256

200

ST305

158

m127813

19

m131340

21

m132123

118

3

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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Page 8

Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PR67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

MS21042L6

Purchased

No

100

Each

435.0000

4

12

MS21042L6

Nut

**

JA

Location

Loc Qty

Loc Code

ST260a

200

m132262

200

12

ST273A

200

m131624

200

ST305

1

m129909

1

t260a

34

m131317

34

MS24694-S109

Purchased

No

100

Each

26.0000

2

6

MS24694-S109

Screw, Flat Head

DAS
24
9-89

AUG 24 2015

**

JA

Location

Loc Qty

Loc Code

Mezz

26

115708

26

132576

100

Each

527.0000

1

63

MS27039-1-07

Purchased

No

MS27039-1-07

Screw

**

JA

JUL 21 2015

Location

Loc Qty

Loc Code

GA

364

125654

364

ST286

163

m127813

155

m130388

8

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PR67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

MS27039-1-23

Purchased No

100 Each

23.0000

1 3

MS27039-1-23

AUG 24 2015

SCREW

**

JA

DAS
24
9-89

Location

Loc Qty

Loc Code

ST284

23

23

(18057)

3

MS51859-6

Purchased No

100 Each

16.0000

8 24

MS51859-6

WASHER

**

JA

Location

Loc Qty

Loc Code

ST273

16

16

(m126474)

4

MS51859-7

Purchased No

100 Each

15.0000

2 20 6

MS51859-7

AUG 24 2015

Washer

**

JA

DAS
24
9-89

Location

Loc Qty

Loc Code

ST273

15

15

(M127992)

1

MS51859-8

Purchased No

100 9 Each

53.0000

8 24

MS51859-8

Washer

**

JA

Location

Loc Qty

Loc Code

ST273

53

53

(m127993)

24

NAS1149F0316P

Purchased No

100 Each

27.0000

1 3

NAS1149F0316P

WASHER

**

JA

JUL 21 2015

Location

Loc Qty

Loc Code

st268

27

27

113644

2

132579

1

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Shop Packet Print

Page 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PR67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149F0432P

Purchased

No

100

Each

1,085.000

16

48

NAS1149F0432P

WASHER

JA

Location

Loc Qty

Loc Code

ST260a

1014

M131697

514

M132551

500

st268

71

M128995

63

M130388

8

NAS1149F0532P

Purchased

No

100

Each

1,860.000

2

6

NAS1149F0532P

Washer

JA

Location

Loc Qty

Loc Code

ST267

1860

18057

1848

m130388

12

NAS1149F0632P

Purchased

No

100

Each

108.0000

8

24

NAS1149F0632P

WASHER

JA

Location

Loc Qty

Loc Code

ST267

108

18057

108

NAS1149F0832P

Purchased

No

100

Each

161.0000

2

6

NAS1149F0832P

WASHER

JA JUL 21 2015

Location

Loc Qty

Loc Code

ST267

161

18057

161

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Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
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OTHER : ☐																					

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Work Order ID: 133793

133793

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

NAS43DD3-61

Purchased

No

100

Each

20.0000

1

3

NAS43DD3-61

Spacer

m128635

**

3

JA

JUL 21 2015

Location

Loc Qty

Loc Code

ST262

20

m127306

1

m128635

19

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

3

PB67-43001-09

Aft Blade Fold Assembly Weldment

**

3133660-3

AUG 24 2015

DAS
24
9-89

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

3

PB67-43001-13

Aft Adjustable Blade Support Assembly

**

133703 MF 15-8-17

PB67-43001-135

Manufactured

No

100

Each

1.0000

1

3

PB67-43001-135

Male Eye

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

100005

1

133703

100

Each

1.0000

1

3 3

PB67-43001-137

Manufactured

No

PB67-43001-137

Locking Sleeve

**

JA

Location

Loc Qty

Loc Code

Mezz2

1

100004

1

133704

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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			OTHER : _____																																																																		

Picklist Print

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Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PB67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-155

Manufactured No

100 Each

2.0000

1 3

PB67-43001-155

Pin

**

JA

Location

Loc Qty

Loc Code

Mezz2

2

110596

1

43092

1

133705

100

Each

0.0000

1

3

PB67-43001-17

Manufactured No

PB67-43001-17

Aft Adjustable Blade Support Assembly

**

PB67-43001-21

Manufactured No

100

Each

0.0000

1

3

PB67-43001-21

Upper Blade Support And Cover Assembly

**

PB67-43001-23

Manufactured No

100

Each

0.0000

1

3

PB67-43001-23

Lower Blade Support And Cover Assembly

**

PB67-43001-261

Manufactured No

100

Each

4.0000

2

6

PB67-43001-261

Lever Arm

**

JA

Location

Loc Qty

Loc Code

Mezz2

4

111102

4

133684

100

Each

6.0000

5

15

PB67-43001-265

Manufactured No

PB67-43001-265

Deltin Bushing

**

JA

Location

Loc Qty

Loc Code

Mezz2

6

113389

6

8133685

#15

Wednesday, June 17, 2015 3:06:48 PM

Shop Packet Print

Page 12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Picklist Print

Wednesday, June 17, 2015 3:06:48 PM

Page 13

Work Order ID: 133793

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

133793

PR67-43001-03

Start Date: 6/17/2015

Required Date: 7/3/2015

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-299

Manufactured No

100

Each

21.0000

2

6

PR67-43001-299

Bushing

**

JA

Location

Loc Qty

Loc Code

Mezz2

21

113390

21

89956

133706

100

Each

0.0000

1

3

**

JA

JUL 21 2015

PB67-43001-305

Manufactured No

PR67-43001-305 *

Bearing

PB67-43001-37

Manufactured No

100

Each

0.0000

1

3

PR67-43001-37

Tube Arm Assembly

PB67-43001-57

Manufactured No

PR67-43001-57

Stabilizer Arm

PB67-43001-59

Manufactured No

PR67-43001-59

Adjustable Attachment Arm

PB67-43001-63

Manufactured No

PR67-43001-63

Handle Assy

100

Each

0.0000

1

3

**

133718 MK

15-8-17

NAS1149DN632J

→ 12

DAS
24
9-89

AUG 24 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

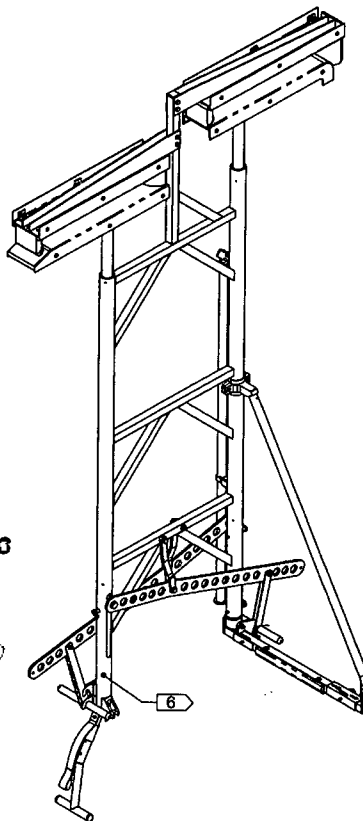
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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELFIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
29	2	AN4-10A	BOLT
30	1	AN4-13A	BOLT
31	4	AN4-15A	BOLT
32	1	AN5-26A	BOLT
33	2	AN6-11A	BOLT
34	2	AN6-16A	BOLT
35	2	AN8-13A	BOLT
36	3	BSP43	RIVET
37	1	CR3213-4-05	RIVET
38	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
39	1	MS17984-C408	QUICK RELEASE PIN
40	3	MS17984-C418	QUICK RELEASE PIN
41	9	MS21042L4	NUT
42	1	MS21042L5	NUT
43	4	MS21042L6	NUT
44	2	MS24694-S109	SCREW
45	1	MS27039-1-07	SCREW
46	1	MS27039-1-23	SCREW
47	8	MS51859-6	NYLON WASHER
48	2	MS51859-7	NYLON WASHER
49	8	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0316P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER



B67-43001-03 AFT BLADE FOLD ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN. POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 50.57 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL ϕ 0.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 10 PL (2 PL PER BUSHING)
- 10) DRILL ϕ 0.250 DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- 12) DRILL A ϕ 0.128 DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
- 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A ϕ 0.128 DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
- 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

mk
#133793

RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR809-011	VS	10.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS	DRAWING NO.	REV. C
CHECKED		B67-43001-03	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		AFT BLADE FOLD ASSY	NTS
DE APPR.	WA	DATE 10.06.14	

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DQA: _____ Date: _____

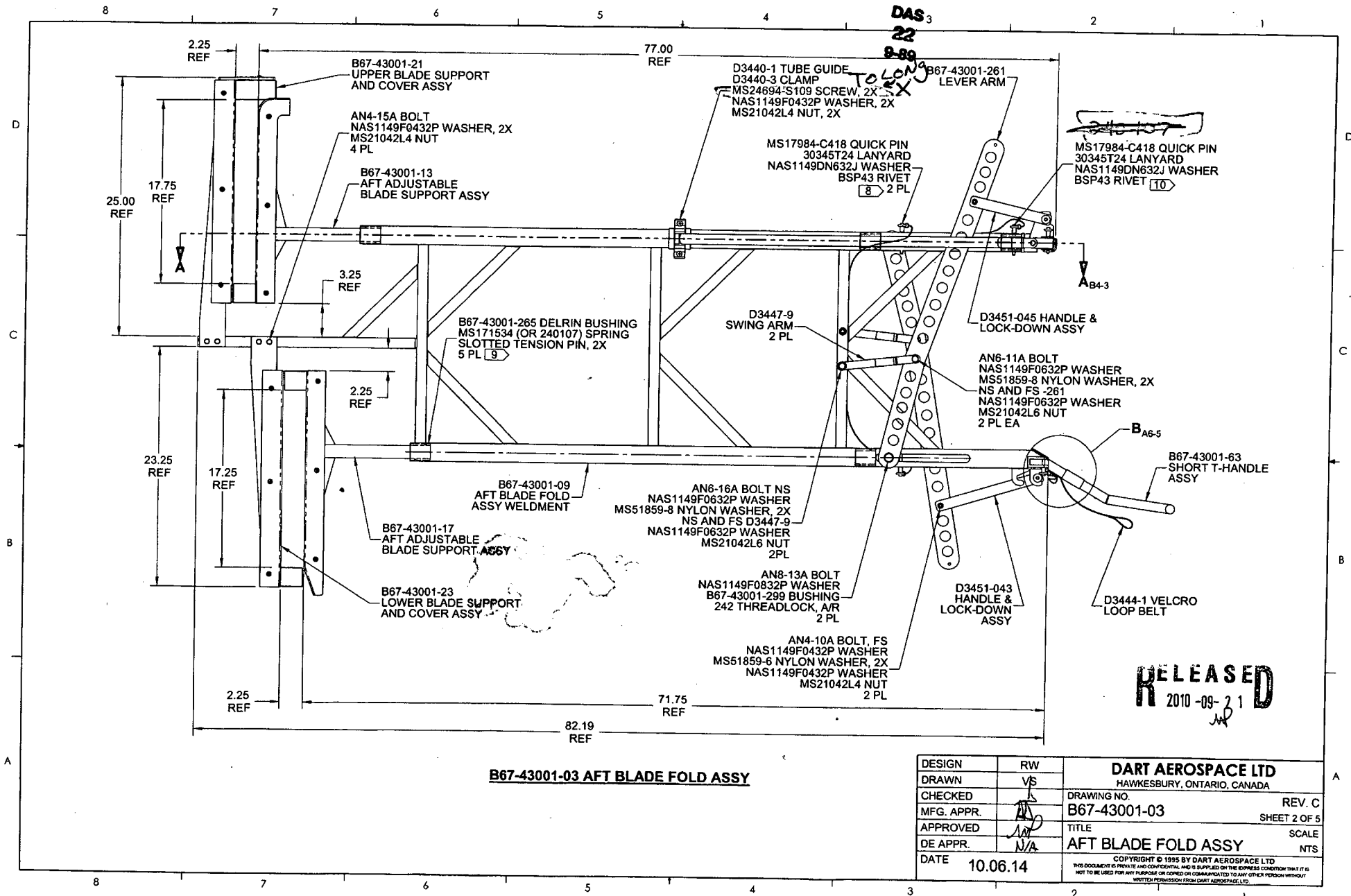


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS + Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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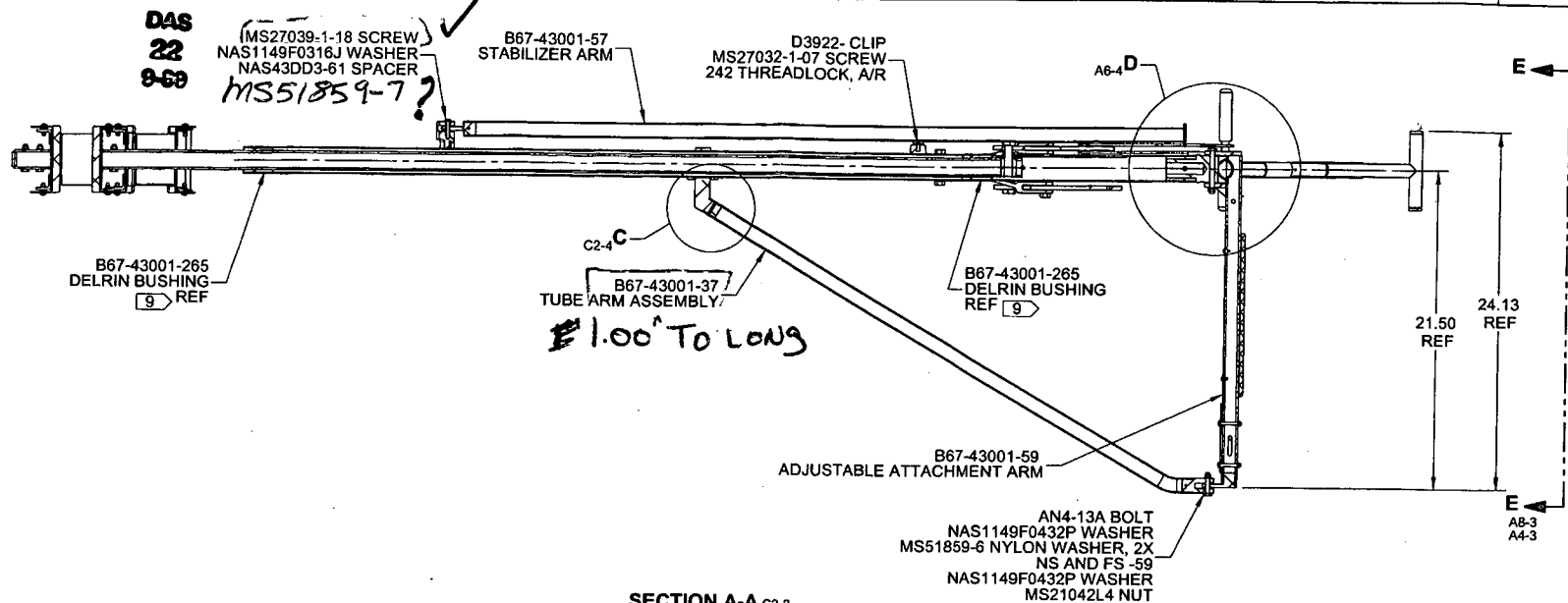


WORK ORDER NON-CONFORMANCE / UPDATE

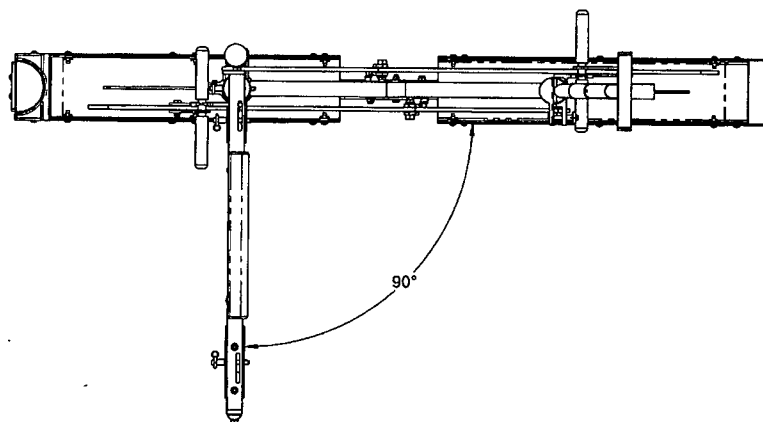
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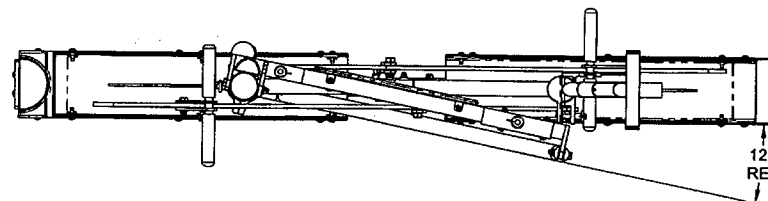
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Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																							



SECTION A-A C2-2



C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION 10



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION 10

RELEASED
R 2010-09-21

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO. B67-43001-03	REV. C
MFG. APPR.		TITLE AFT BLADE FOLD ASSY	SHEET 3 OF 5
APPROVED		SCALE NTS	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.14		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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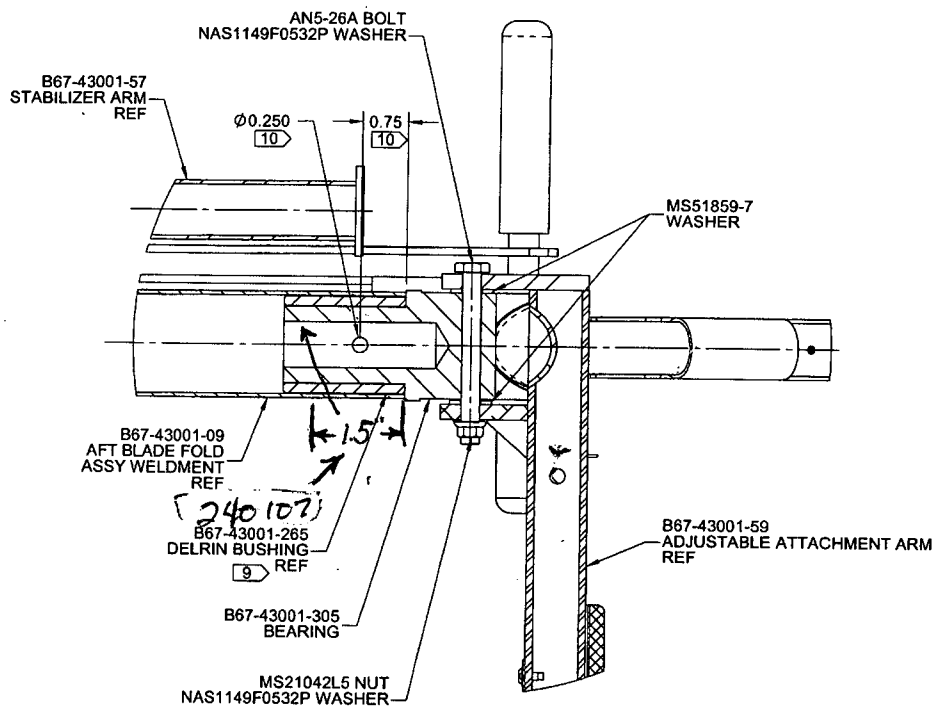
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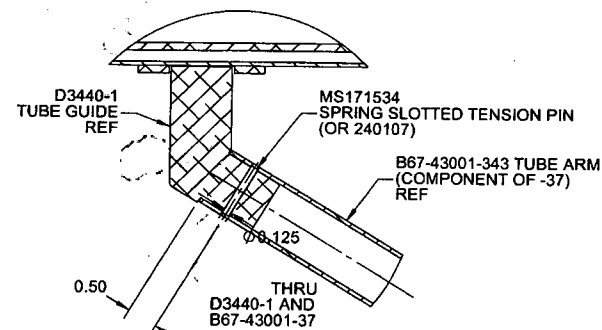
C

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DETAIL D
SCALE 5X D3-3



DETAIL C D5-3
SCALE 5X

RELEASED
2010-09-21
JNY

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO. B67-43001-03	REV. C
MFG. APPR.		TITLE	SCALE
APPROVED		AFT BLADE FOLD ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.14		

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

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B67-43001-137
LOCKING SLEEVE
REF

3408A98 DETENT
BALL PLUNGER

B67-43001-243
TUBE HANDLE EXTENSION
(COMPONENT OF -09)
REF

MS171532 SPRING
SLOTTED TENSION
PIN (OR 204107)

B67-43001-155
PIN

$\phi 0.125$

0.27

B67-43001-135
MALE EYE

MS51859-6
NYLON WASHER

B67-43001-133 CLEVIS
(COMPONENT OF -63)
REF

DONT FIT

N/A

DONT FIT

13 SECTION F-F B4-5

D3449-1
PAD 14

0.88
REF

F

B67-43001-137
LOCKING SLEEVE

F

DAS 22 9-80 MS17984-C408
QUICK RELEASE PIN

TO SHORT

CR3213-4-05 RIVET
NAS1149DN632J WASHER
30345T21 LANYARD

D3444-1
VELCRO LOOP BELT
REF

*NOT IN
PICK LIST*

13 DETAIL B C2-2
SCALE 10X

RELEASED
2010-09-20

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	VS	DRAWING NO. B67-43001-03	REV. C
MFG. APPR.	VS	TITLE	SHEET 5 OF 5
APPROVED	VS	AFT BLADE FOLD ASSY	SCALE NTS
DE APPR.	VS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.14		

8 7 6 5 4 3 2 1

DQA: _____ Date: _____

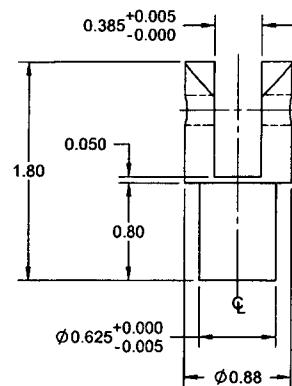


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



B67-43001-133 CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

**DAS
22
9-88**

~ ACCEPTABLE TO
GRIND TO FIT B67-43001-135
AT ASSY OF
B67-43001-63



RELEASED
2009-09-24
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD		
DRAWN	h	HAWKESBURY, ONTARIO, CANADA		
CHECKED	ASB	DRAWING NO.	REV. C	
MFG. APPR.	AW	B67-43001-133	SHEET 1 OF 1	
APPROVED	AW	TITLE	SCALE	
DE APPR.	N/A	CLEVIS	NTS	
DATE	09.02.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____

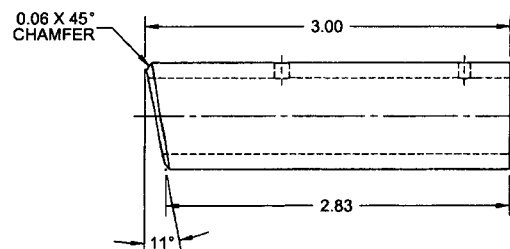
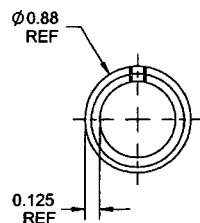
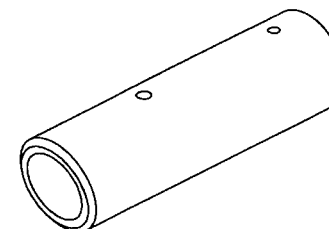
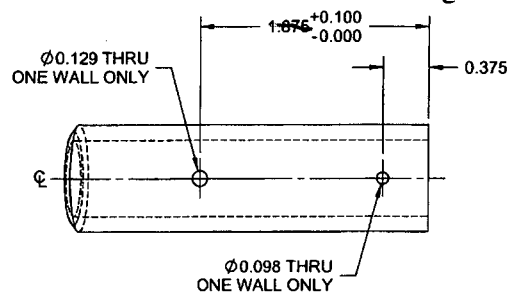


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



B67-43001-157 TUBE

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T0.875W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	FW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	JS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-157	SHEET 1 OF 1	
APPROVED	N/A	TITLE	SCALE	
DE APPR.	N/A	TUBE	NTS	
DATE	09.02.27			
COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				